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D2563 Job Sheet 193290



Part No: D2563

Job Qty: 6 pcs

Part Name: Step Weldment Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/10/19

Job Tracking No: 15298

Due Date: 4/26/19

Created By: Dara Macdonald

Type: SOLD

Description:

Note: DWG REV C IPP Rev:G 02.07.31 Re-format Location RF

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy-1	6 pcs	4/26/19	4/26/19	0.00	8.82	Large Fab - 1		APR 22 2019
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3	DAS	
							Large Fab - 4	24	
							Large Fab - 5	9-89	
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
110	QC 9	6 pcs	4/26/19	4/26/19	0.00	0.00	QC 9 - 10		DAS 43 9-89
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
120	QC 5	6 pcs	4/26/19	4/26/19	0.00	0.00	QC 5 - 10		DAS 43 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		

				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
130 Handfinish - 1-1 Chemical- B4B	6 pcs	4/26/19	0.00 1.61	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	D.R19/09/22
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
140 QC 7	6 pcs	4/26/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	

DAS
APR 22 2019 58
9.89

					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
150 Large Fab - Welded Assy-2-B4B	6 pcs	4/26/19	0.00 8.82		Large Fab - 1 - B4B	
					Large Fab - 10 - B4B	
					Large Fab - 2 - B4B	
					Large Fab - 3 - B4B	DAS
					Large Fab - 4 - B4B	24
					Large Fab - 5 - B4B	9-89
					Large Fab - 6 - B4B	
					Large Fab - 7 - B4B	
					Large Fab - 8 - B4B	
					Large Fab - 9 - B4B	
160 QC 10	6 pcs	4/26/19	0.00 0.00		QC 10 - 10	
					QC 10 - 18	
					QC 10 - 24	
					QC 10 - 43	JAS
					QC 10 - 50	43
					QC 10 - 58	9-89
					QC 10 - 9	
170 QC 5	6 pcs	4/26/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	DAS
					QC 5 - 49	43
					QC 5 - 51	9-89
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
175 Handfinish - 2-1 Pressure- B4B	6 pcs	4/26/19	0.00 1.61		Handfinish - 2 - 1 - B4B	
					Handfinish - 2 - 2 - B4B	DR 19/04/23
					Handfinish - 2 - 3 - B4B	
					Handfinish - 2 - 4 - B4B	
180 Powdercoat - 1 White Gl(A)-B4B	6 pcs	4/26/19	0.00 1.00		Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	BL 19-04-23
					Powdercoat - 4 - B4B	
190 Handfinish - 3-1- WingWalk-B4B	6 pcs	4/26/19	0.00 1.61		Handfinish - 3 - 1 - B4B	
					Handfinish - 3 - 2 - B4B	
					Handfinish - 3 - 3 - B4B	
					Handfinish - 3 - 4 - B4B	
					Handfinish - 3 - 5 - B4B	
200 QC 3	6 pcs	4/26/19	0.00 0.00		QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	

				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
210 Packaging 3-1 - Stock - B4B	6 pcs	4/26/19	0.00 0.00	Packaging 3 - 1 - B4B	DAS
				Packaging 3 - 2 - B4B	46 APR 2 5 2019
				Packaging 3 - 3 - B4B	9-89
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
220 QC 21 - SA	6 pcs	4/26/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21 APR 2 6 2019
				QC 21 - SA - 53	9-89

Part Op 100 - (Weld per dwg A/R Aluminum rod Batch: _____) 1-Cut D2244 to 89.70" at 34 deg as per dwg D2563 2-Deburr ends
 Descriptions: 3-Weld (1 END CAP, LUG PLATES & MOUNTING ANGLE) as per dwg D2563 using DT 8343 4- Grind
 110 - (QC9- Inspect visual per QSI004- Fusion Welds)
 120 - (QC5- Inspect part completeness to step on W/O)
 130 - (Chemical Conversion Coat per QSI005 4.1)
 140 - (QC7-Inspect Chemical Conversion Coat)
 150 - (Weld per dwg A/R Aluminum rod Batch: _____) 1-Inspect for foreign object per QSI 024 2-Weld Remaining End cap
 as per Dwg D2563 using DT 8343 3-Grind
 160 - (QC10- Inspect visual per QSI004- ground welds)
 170 - (QC5- Inspect part completeness to step on W/O)
 175 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Touch up Alodine as per QSI005
 180 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) Touch up Alodine then Powder Coat White Gloss (Ref: 4.3.5.1) as

per QSI 005 4.3 START TIME: _____
190 - (Wing Walk as per dwg QSI005 4.4 Batch _____)
200 - (QC3- Inspect Part Finish)
210 - (Identify as per dwg & Stock Location: _____)
220 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2244-116	Step Extrusion	6 pcs (1 ea)	100-Large Fab - Welded Assy-1	164533
D2561	Lug	12 pcs (2 ea)	100-Large Fab - Welded Assy-1	5160076
D2564	Mounting Angle	12 pcs (2 ea)	100-Large Fab - Welded Assy-1	5165433
D2673-34	End Plate	6 pcs (1 ea)	100-Large Fab - Welded Assy-1	5161432
D2673-34	End Plate	6 pcs (1 ea)	150-Large Fab - Welded Assy-2- B4B	5161432

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	D2244-116	6	75	0
	D2561	12	24	0
	D2564	12	47	0
	D2673-34	6	38	0
150-Large Fab - Welded Assy-2- B4B	D2673-34	6	38	0

Part Specifications

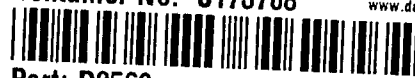
Specifications could not be found.

Plex 4/10/19 9:06 AM Dart.Macdonald.Dara

009344



Container No: S173708



Part: D2563

Job No: 193290

Serial No/Batch: S173708

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 04/22/19